

HVLP Transtec gravity feed spray gun

Model SGK-600-BV

Specifications:

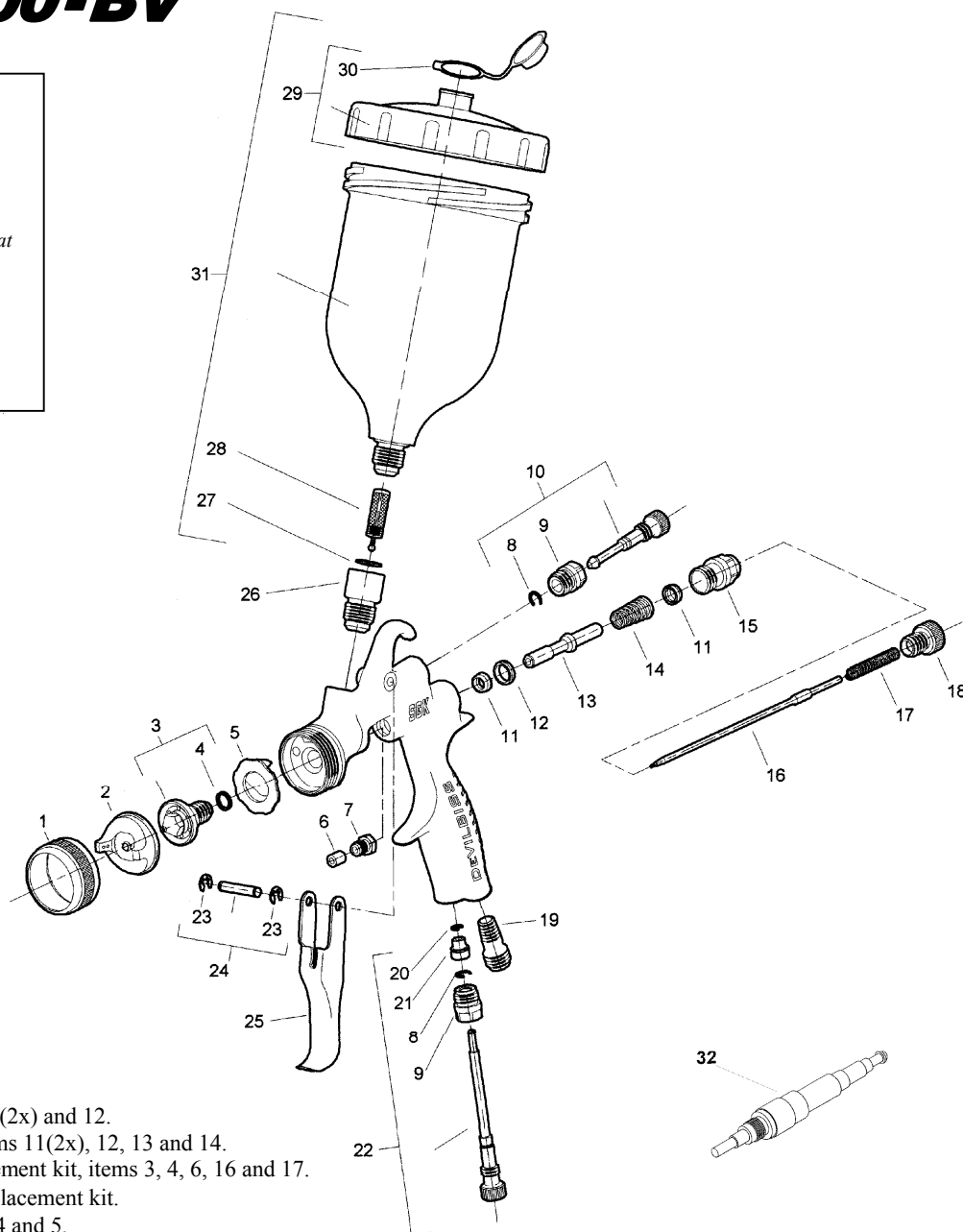
- Pressure at spray gun inlet: up to 32 psi
- Paint flow rate: 190 ml/min
- Air consumption: 9,8 cfm
- Pattern size: 11" at 7" distance

Note: Figure obtained with metallic polyester base at 16 seconds viscosity #4 Ford cup.

Benefits:

- Less overspray
- Paint savings
- Cost reduction

Respect your work and protect
your equipment:
**USE DEVILBISS ORIGINAL
SPARE PARTS.**



Replacement kits

- K-5026: Seal replacement kit, items 11(2x) and 12.
- K-5027: Air valve replacement kit, items 11(2x), 12, 13 and 14.
- ★ K-5028-14: Tip, needle and gasket replacement kit, items 3, 4, 6, 16 and 17.
- ▽ K-5029: Items 4, 11(2x), 12 and 32 replacement kit.
- K-5030: Baffle replacement kit, items 4 and 5.

Ref.	Part N.º	Description	Ref.	Part N.º	Description
1	SGK-0023	Retaining ring	★ 17	SGK-0400	Fluid needle spring
2	BSK-0158-510	Air cap	18	SGK-0035	Fluid adjustment knob
★ 3	-	Fluid tip	19	PTGA-0029	Nipple
★▽● 4	-	Gasket	20	BSS-240104	Retaining ring
● 5	-	Baffle	21	SGK-0041	Air adjusting valve head
★ 6	SGK-0037	Packing	22	SGK-0502	Air adjusting valve assembly
7	SGK-0036	Packing gland nut	23	BSS-240106	Retaining ring
8	SST-8416	Retaining ring	24	K-5025	Trigger pin assembly
9	SGK-0500	Spray pattern adjustment valve bushing	25	SGK-0020	Trigger
10	SGK-0501	Spray pattern valve	26	SGK-0021	Fluid nipple
□○▽11	-	U-cup seal	27	KGP-0012	Gasket
□○▽12	-	Air valve seat	28	KGP-0005	Filter
○13	-	Air valve stem	29	GFC-0402	Lid assembly
○14	SGK-0032	Air valve spring	30	GFC-0002	Drip free vent lid
15	SGK-0034	Air valve bushing	31	GFC-0501	Cup assembly
★ 16	-	Fluid needle	▽ 32	-	Assembly tool

Service Instructions

BYC-068-A

Description

The SGK-600BV spray gun has Transtec HVLP technology and is gravity fed. It is a high production spray gun, ideal for spraying finishing materials, with exception of corrosive and abrasive ones. It renders paint economy, less overspray and ,consequently, reduces costs.

Installation

Connect the spray gun to a clean air source, free of humidity and oil, by using at least a 5/16" internal diameter hose. Depending on the length of the hose, a bigger internal diameter may be necessary. Press the spray gun trigger and adjust the inlet air pressure at the handle of the gun to approximately 25 psi.

Operation

- Prepare the material to be sprayed according to the manufacturer's instructions. Filter the material through a 100 mesh screen.
- Regulate the air pressure at the DeVilbiss filter regulator
- Make a spray test.
- Regulate the spray pattern by opening or closing the spray pattern valve knob (10)
- Spray a small area to adjust the work speed and desired finishing. If finishing is too dry or rough, the amount of material is too small in relation to the air pressure. Turn the fluid adjustment knob (18) counter clockwise, or decrease the air pressure at the filter regulator.
- Keep the spray gun always perpendicular to the surface being painted.
- Do not move your hand in an arch. The arch movement produces a non-uniform paint layer.
- We recommend the spray gun be kept at a distance of 6 to 8 inches from the surface.
- The position of the air cap determines the position of the pattern. Turn the air cap according to requirements.

Maintenance and Cleaning

We recommend cleaning be done after using equipment:

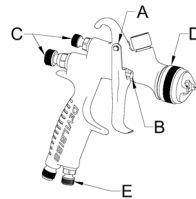
1. Disconnect the spray gun from the air line.
2. Clean the cup and put clean solvent in same.
3. Open totally the fluid adjustment knob, press the trigger and let the solvent flow through the fluid passage until it comes out completely clean.
4. Clean the gun body with a cloth wet with solvent, avoid waste of cotton
5. Remove the air cap and wash it in solvent using a brush or soft bristle brush. Then dry it with an air jet.
6. If necessary, clean the air cap hole with a bristle or toothpick. NEVER USE steel wire or hard instrument for this may damage the hole causing a distorted spray pattern.
7. To avoid damaging the needle, make sure to pull the trigger and keep it pulled while you are tightening or releasing the fluid tip, or remove the fluid adjustment knob (18) to release the spring pressure.
8. Only remove the fluid tip when changing same or when there is internal clogging.
9. For routine cleaning it is not necessary to remove the cup.
10. The recommended tightening of the tip is 150-180 lbf.inch.

Note: To replace both U-cup seal (11) and air valve seat (12) see the procedure described in Service Instructions of the K-5029 kit.

Lubrication

For best results, oil the indicated points daily

We recommend the use of the SSL-10 DeVilbiss oil.



- A. Trigger areas
- B. Needle gasket
- C. Adjustment valves
- D. Retaining ring
- E. Air valve

Service Check			
Defect		Causes	Correcting
Heavier spray on top or below.		a. Material buildup at air cap. b. Partial obstruction of air cap horn holes or central holes.	a. Remove air cap and wash it with solvent. b. Remove air cap and wash it with solvent (see maintenance and cleaning).
Defective configuration in curve shape.		c. Material buildup at the fluid tip or partial obstruction of same. d. Damaged fluid tip.	c. Remove the tip and wash it with solvent. d. Replace the tip and needle assembly.
Heavy spray in the center		a. Excess material. b. Very thick material.	a. Reduce the material flow by closing the fluid adjustment knob. b. Dilute the material.
Split spray.		a. Air pressure too high. b. Lack of material.	a. Reduce air pressure at DeVilbiss filter regulator. b. Increase material flow opening fluid.
Jerky or fluttering spray.		a. Lack of material. b. Obstructed fluid passage. c. False entrance of air in paint line.	a. Refill paint recipient. b. Clean fluid passage. c. Check paint line.
Will not spray.		a. Low air pressure at spray gun. b. Fluid regulating knob closed. c. Material is too thick. d. Air cap is loose. e. Material buildup in between tip and air cap.	a. Check air line or increase pressure. b. Open fluid adjustment knob (see Operation). c. Dilute material. d. Tighten air cap. e. Clean tip externally and the central air cap hole.
Dripping or material leakage through the tip.		a. Fluid tip or needle worn or damaged. b. Gasket holding the needle.	a. Change the tip and needle assembly (see item 7 in Maintenance and Cleaning). b. Lubricate the gasket (item 6) when new, or change it, lubricate and adjust.

With 14 psi at spray gun inlet air cap pressure is 10 psi.

DeVilbiss maintains the right to modify the characteristics of its products without previous notice.

Warranty

- DeVilbiss equipment has a six month warranty from the date of purchase. This warranty will be limited to material, manufacturing and workmanship defects; bad use or repairs effected by non authorized people imply in automatic loss of the warranty;
- When repairs are necessary, take your equipment to a DeVilbiss Authorized Distributor where the repair will be effected by specialized technical people and only charged if equipment it outside warranty.